

28/11/2008 2:54:22 PM
wson

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name : SADDLE, INBOARD, LS, 206

43852

Estimate Number : 10820

P.O. Number :

This Issue : 28/11/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : MACHINED PARTS

Previous Run : 41612

Written By :

Checked & Approved By : JW 08.12.01

Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house
processEC
Est Rev:D As per Rev D 07-03-19 JLM

Part Number : D26661

Drawing Number : D2666 REV. D

Project Number : N/A

Drawing Revision : D

Material :

Due Date : 20/12/2008 Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101001

Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
7075-T7351 2X6X6.25
Issue material from stock:
Cut Size 2.0 x 6.25 X 6.0
Grain Along Long 6.0 Length

Batch No: B 34872 ml 08/12/30 (6)

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program batch number.
1- Inspect part number and batch number are programmed correctly.
2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
5- Deburr

ml 08/12/30 (6)

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine Keyway and inspect per attached dimension sheet

ml 09/01/05 (6)

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 08/12/30 (6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 28/11/2008 2:54:22 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, LS, 206

Job Number: 43852

Part Number: D26661

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SL 09/01/06

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL 09-07-01 X6

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:10

OVEN TEMPERATURE:

320

FINISH TIME:

9:40

FL 09/01/08

6

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-07-01 X6

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 426

9/1/7

SL

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/07

MF 09-01-07

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43852	
Description: 206 Saddle, Inboard, Left side		Part Number: D2666-1	
Inspection Dwg: D2666 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.117	.117	.116		
B	0.100	0.140		.110	.111	.111	.111		
C	2.470	2.510		2.488	2.490	2.490	2.490		
D	0.100	0.180		.143	.140	.140	.140		
E	0.210	0.230		.215	.228	.223	.229		
F	1.313	1.343		1.316	1.336	1.326	1.326		
G	0.240	0.260		.240	.251	.248	.247		
H	0.615	0.685		.665	.645	.654	.650		
I	1.125	1.145		1.139	1.140	1.140	1.140		
J	0.990	1.010		1.001	1.001	1.001	1.001		
K	0.235	0.240		.236	.236	.236	.236		
L	0.510	0.515		.511	.511	.511	.511		
M	0.100	0.120		.110	.110	.110	.112		
N	1.565	1.585		1.576	1.575	1.574	1.574		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.499	2.500	2.500	2.500		
R	0.490	0.510		.500	.498	.499	.500		
S	0.313	0.318		.315	.315	.315	.315		
T	2.495	2.505		2.499	2.500	2.499	2.500		
U	1.357	1.367		1.359	1.363	1.363	1.363		
V	0.315	0.322		.321	.321	.321	.321		
W	0.540	0.560		.549	.549	.550	.549		
X	1.674	1.684		1.679	1.680	1.681	1.680		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	JNL
Date:	08/12/30

Audited by:	J.L
Date:	08/01/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 43852
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.119	.118				
B	0.100	0.140		.111	.111				
C	2.470	2.510		2.490	2.496				
D	0.100	0.180		.140	.140				
E	0.210	0.230		.223	.223				
F	1.313	1.343		1.326	1.326				
G	0.240	0.260		.247	.247				
H	0.615	0.685		.647	.653				
I	1.125	1.145		1.140	1.140				
J	0.990	1.010		1.001	1.001				
K	0.235	0.240		.236	.236				
L	0.510	0.515		.510	.510				
M	0.100	0.120		.110	.110				
N	1.565	1.585		1.575	1.574				
O	5.990	6.010		6.000	6.000				
P	1.245	1.255		1.250	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.490	0.510		.501	.500				
S	0.313	0.318		.315	.315				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.363	1.363				
V	0.315	0.322		.321	.321				
W	0.540	0.560		.549	.549				
X	1.674	1.684		1.681	1.681				
Y	0.257	0.262		.259	.259				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>mf</i>
Date:	08/12/30

Audited by:	JL
Date:	09/01/06

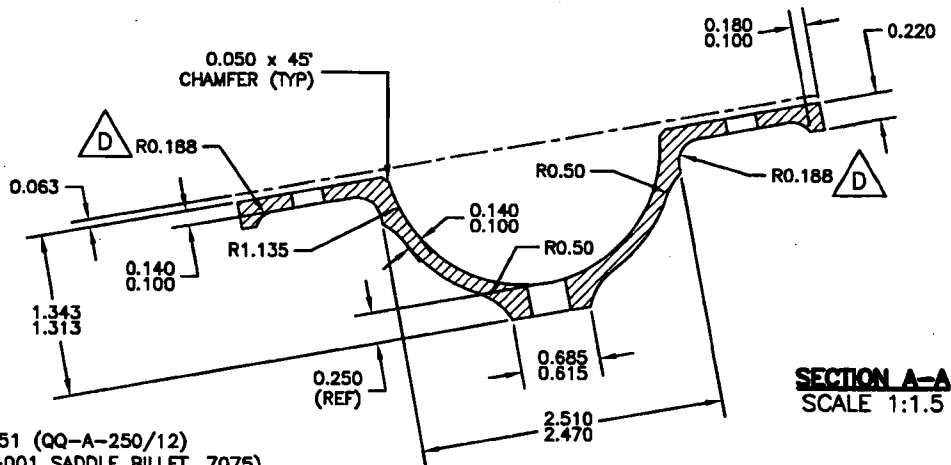
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>



DESIGN	<i>PH</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	DRAWING NO. D2666
				REV. D
DATE	06.11.08	TITLE	SADDLE FWD INSIDE HIGH	SHEET 1 OF 1
		SCALE	1:3	
A	97.03.25	NEW ISSUE		
B	97.07.11	ANGLE AND NOTES ADDED		
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313		

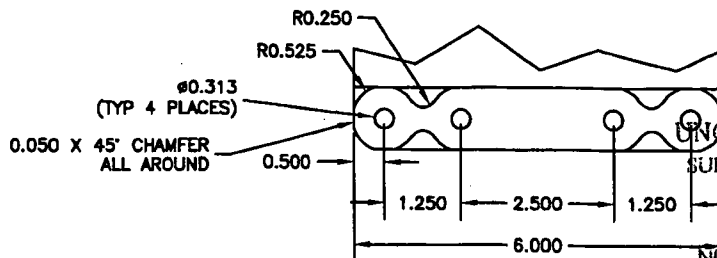
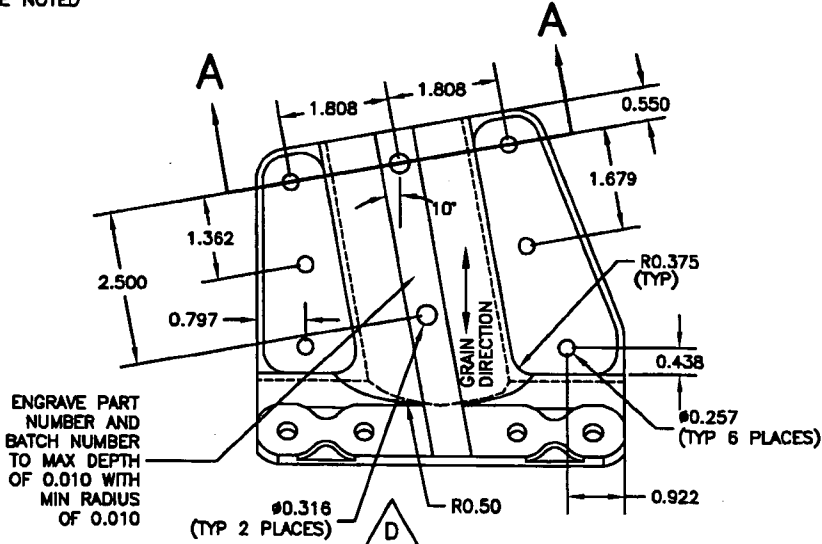
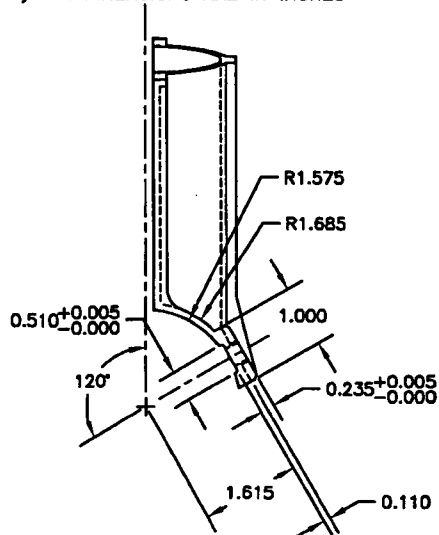
RELEASED

07.02.12 *PH*



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



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WORK ORDER

NO. 43852

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